

**Work Order ID 61641**

August 31, 2010 8:28:42 AM

Page 1

Item ID: D3121-241

Accept

Setup Start

Revision ID:

Stop

Item Name: Bearing Assembly

Start Date: 8/31/10 Start Qty: 10.00

Cust Item ID:

Required Date: 8/31/10 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3121

Rev E

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Turn D3121-25 Cap as per Folio FA387□2-Deburr

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

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Item ID: D3121-241

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Stop



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Cust Item ID:

Required Date: 8/31/10 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Press D3121-23 Bearing into D3121-25 Cap as per Dwg D3121

*EP 10/08/31* (11X)

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*SP 10/08/31*

(11)

150

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

*G-A 10X*  
*St 235B 10X*

*EP 10/08/31* (11X)

**Work Order ID 61641**

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Item ID: D3121-241

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearing Assembly

Start Date: 8/31/10 Start Qty: 10.00



Cust Item ID:

Required Date: 8/31/10 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/31

mt

10-8-31

# Picklist Print

August 31, 2010 8:28:39 AM

Page 1  
T

Work Order ID: 61641



Parent Item: D3121-241

Parent Item Name: Bearing Assembly

Start Date: 8/31/10

Required Date: 8/31/10

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 104.02.18 New issue J/KJ/DS  
IPP Rev:B ECN 1060 07-11-12 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MDELNR1.000		Purchased	No			100	f	22.1400	0.052	0.52			
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Delrin Round Bar 1"

N/A

Location	Loc Qty	Loc Code
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MAT	16.85	
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114733	16.85	
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MAT050	5.29	
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108804	5.29	
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D3121-23

Manufactured No

130 Each

38.0000

1

10



Bearing

Location	Loc Qty	Loc Code
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ST235	38	
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56591	2	
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60708	36	
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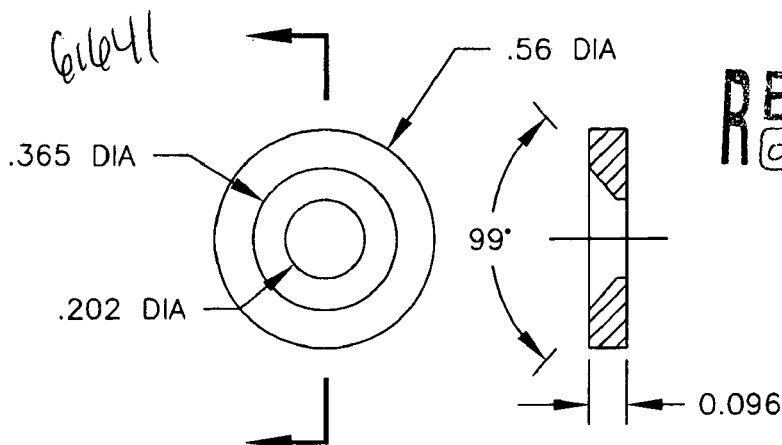
EP 5/10/08/31

10 B 58200  
EP 5/10/08/31

pull from stock  
D3121-25

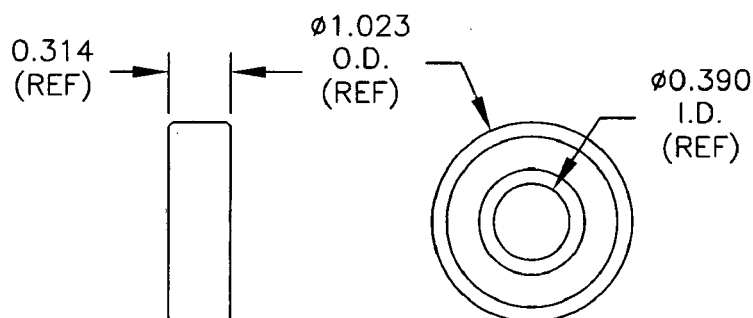


DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1



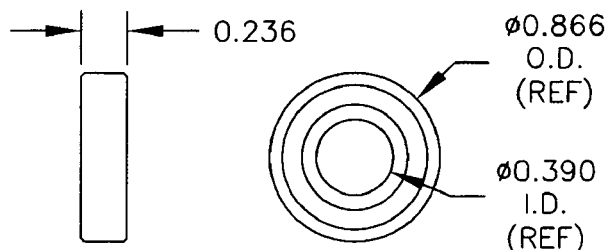
#### **D3121-17 WASHER (SCALE 2:1)**

- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



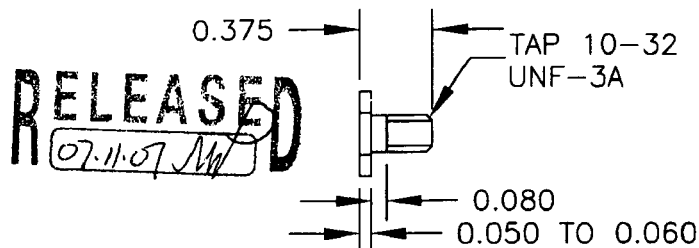
#### **D3121-19 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES



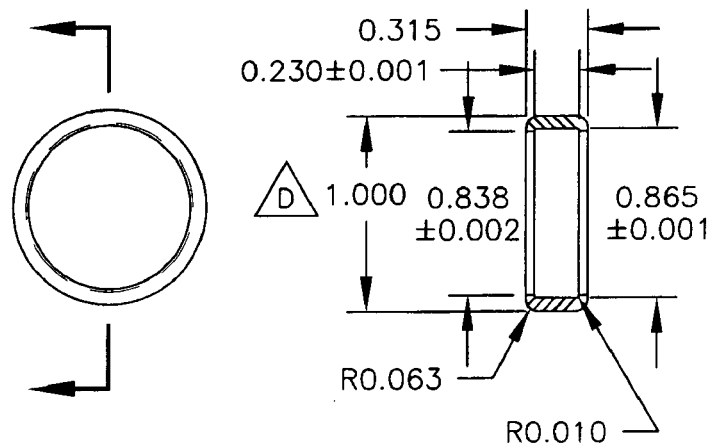
#### **D3121-23 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-2Z
- 2) ALL DIMENSIONS ARE IN INCHES



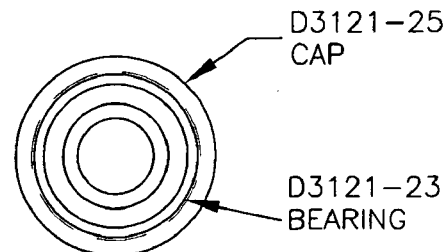
#### **D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



#### **D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES



#### **D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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